

Order 11943



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4436-047
Job Sheet 188881



008230

Part No: D4436-047

Job Qty: 4 pcs

Part Name: Aft Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D4436 REV.B IPP REV:A 18.11.13 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/12/19		0.15	1.28	Small Fab - 1		DAS 58 9-89 FEB 25 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	2/12/19		0.00	0.00	QC 5 - 10		DAS 68 9-89 FEB 25 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
160	Packaging 3-1 - Stock - B4B	4 pcs	2/12/19		0.00	0.00	Packaging 3 - 1 - B4B		Plex 1/29/19 3:23 PM Dart.Hadley.Shannon
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

Rush!!!

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	2/12/19	0.00 0.00	QC 21 - SA - 21	DAG 21 FEB 25 2019
				QC 21 - SA - 70	9-86
Part Op 100 - Small Fab Assemble as per dwg and install grommet ***TORQUE SCREWS AS PER NOTE 8 SHEET 4*** Descriptions: 110 - QC5- Inspect part completeness to step on W/O 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
AN525-832R6	Screw	16 Ea (4 ea)	100-Small Fab - 1	5133786	
D4435-047	Bracket Assembly	4 pcs (1 ea)	100-Small Fab - 1	5152436	
D4436-045 (3)	Aft Inboard Bracket Assembly	4 Ea (1 ea)	100-Small Fab - 1	5135845	SIS-1670
D4436-049	Aft Outboard Bracket Assembly	4 Ea (1 ea)	100-Small Fab - 1	5105052	
D4440-1	Grommet	4 pcs (1 ea)	100-Small Fab - 1	5148619	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	AN525-832R6	16	312	0	
	D4435-047	4	0	0	
	D4436-045	4	5	0	
	D4436-049	4	0	0	
	D4440-1	4	259	0	
Part Specifications					
Specifications could not be found.					

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D4436-047

Job Sheet 188881



Part No: D4436-047

Job Qty: 4 ea

Part Name: Aft Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D4436 REV.B IPP REV:A 18.11.13 NEW ISSUE DD VERF:JFS

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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/12/19	2/12/19	0.00	0.00	Start Up Small Fab		
100	Small Fab	4 pcs	2/12/19	2/12/19	0.15	1.28	Small Fab-6		
110	QC	4 pcs	2/12/19	2/12/19	0.00	0.00	QC5		
160	Packaging	4 pcs	2/12/19	2/12/19	0.00	0.00	Packaging3-2		
170	QC21-SA	4 Ea	2/12/19	2/12/19	0.00	0.00	QC21		

Part Op
Descriptions: 100 - Assemble as per dwg and install grommet ***TORQUE SCREWS AS PER NOTE 8 SHEET 4***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN525-832R6	Screw	16 Ea (4 ea)	90-Start up Operation	
D4435-047	Bracket Assembly	4 Ea (1 ea)	90-Start up Operation	5152436
D4436-045	Aft Inboard Bracket Assembly	4 Ea (1 ea)	90-Start up Operation	
D4436-049	Aft Outboard Bracket Assembly	4 Ea (1 ea)	90-Start up Operation	
D4440-1	Grommet	4 pcs (1 ea)	90-Start up Operation	

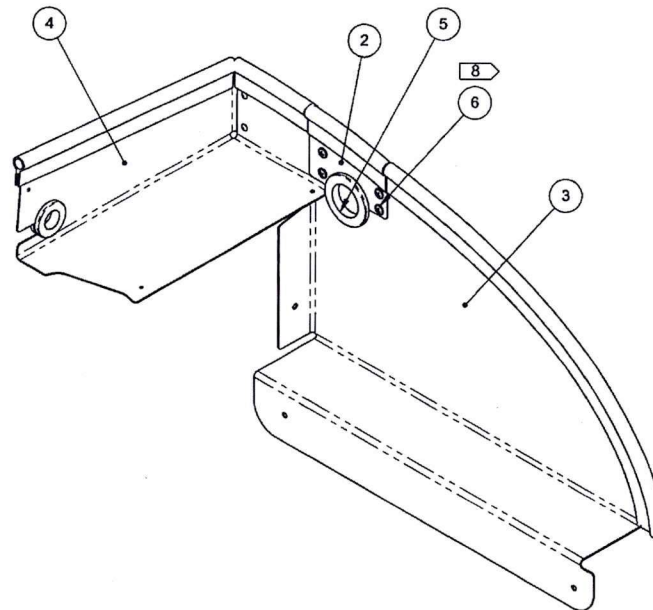
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN525-832R6	16	324	0
	D4435-047	4	0	0
	D4436-045	4	5	0
	D4436-049	4	0	0
	D4440-1	4	13	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW, WASHER HEAD



D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREWS TO 12-15 (in-lb)

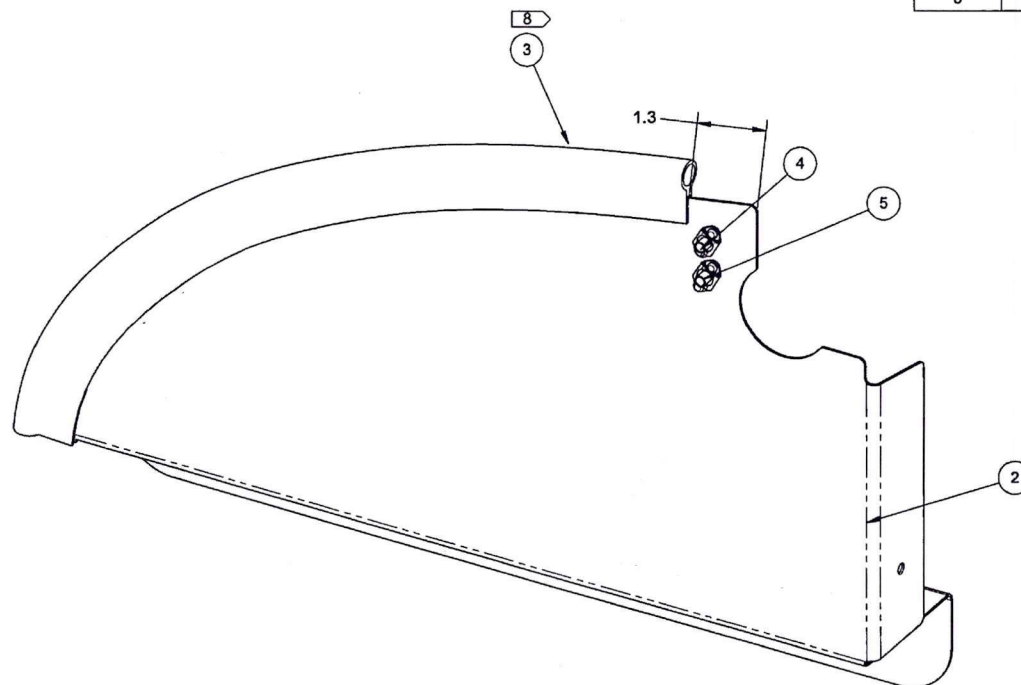
RELEASED

2019 OCT 19
ECN18-826

B	ADD D4436-9 BRACKET, D4436-047 ASSY, D4436-049 ASSY. REF. PAR18-256	PM	18.09.18
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4436 REV. B SHEET 1 OF 11 TITLE COVER ASSEMBLY SCALE NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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APPROVED	VS		
DE APPR.	DS		
DATE	18.09.18		

APPROVED

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE, SELF-LOCKING, FLOATING
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

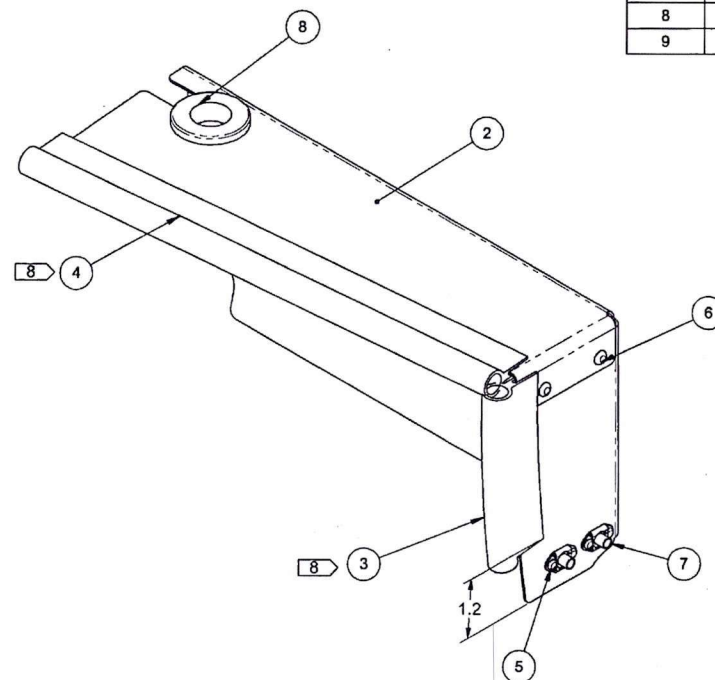
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

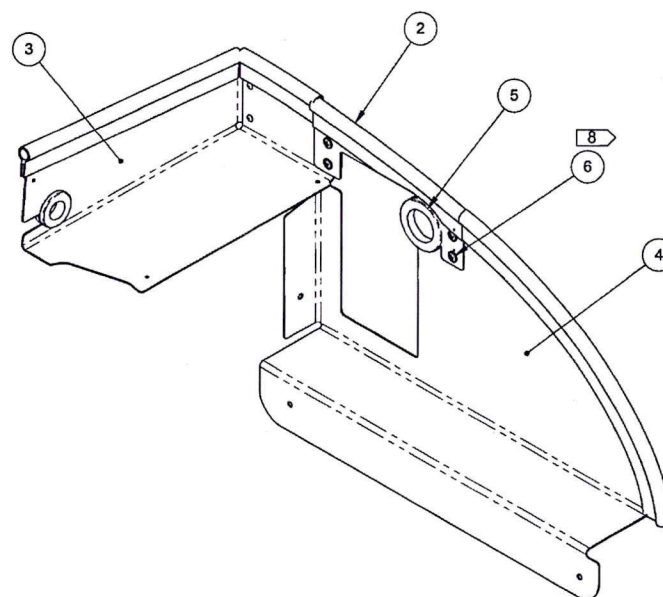
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2018 OCT 19

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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4436-047	AFT BRACKET ASSEMBLY
2	1	D4435-047	BRACKET ASSEMBLY
3	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
4	1	D4436-049	AFT OUTBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW, WASHER HEAD



D4436-047 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.15 lbs
- 8) TORQUE SCREWS TO 12-15 (in-lb)

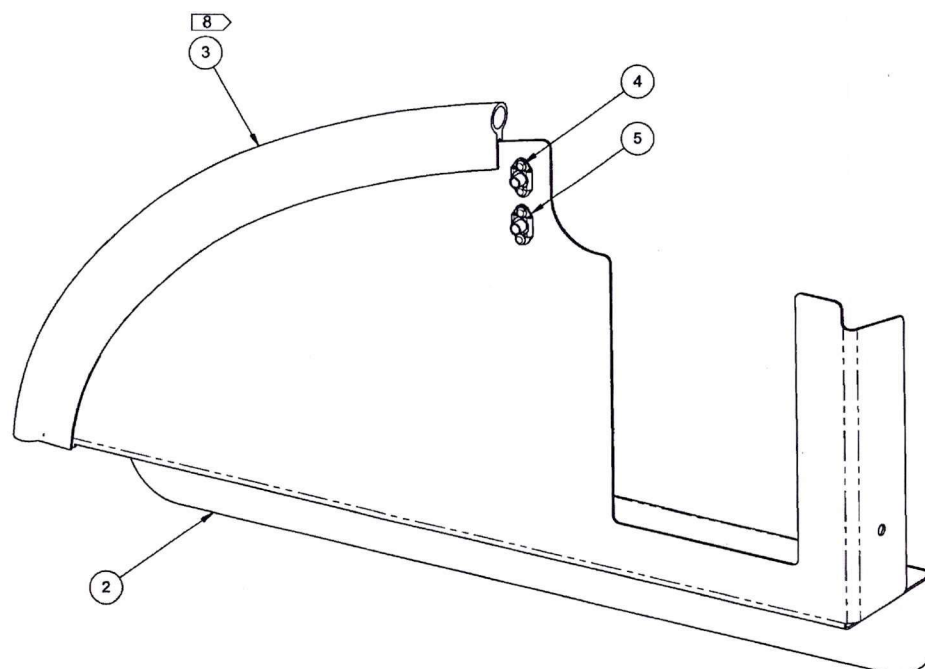
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2019 OCT 19

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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D4436-049	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-9	BRACKET
3	1	D4441-1-124	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE, SELF-LOCKING, FLOATING
6	A/R	3M 1300/1300L	ADHESIVE



D4436-049 AFT OUTBOARD BRACKET ASSEMBLY

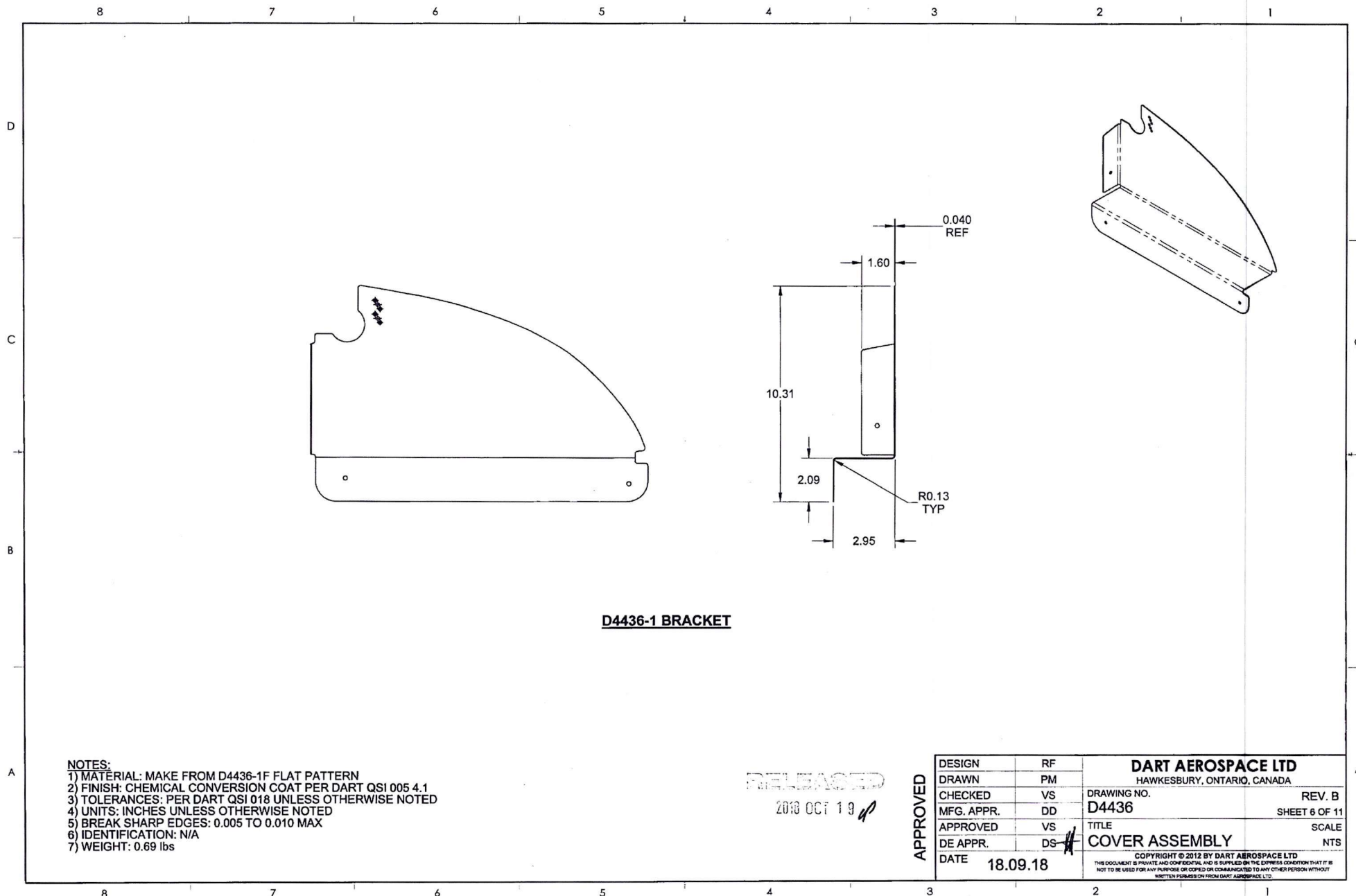
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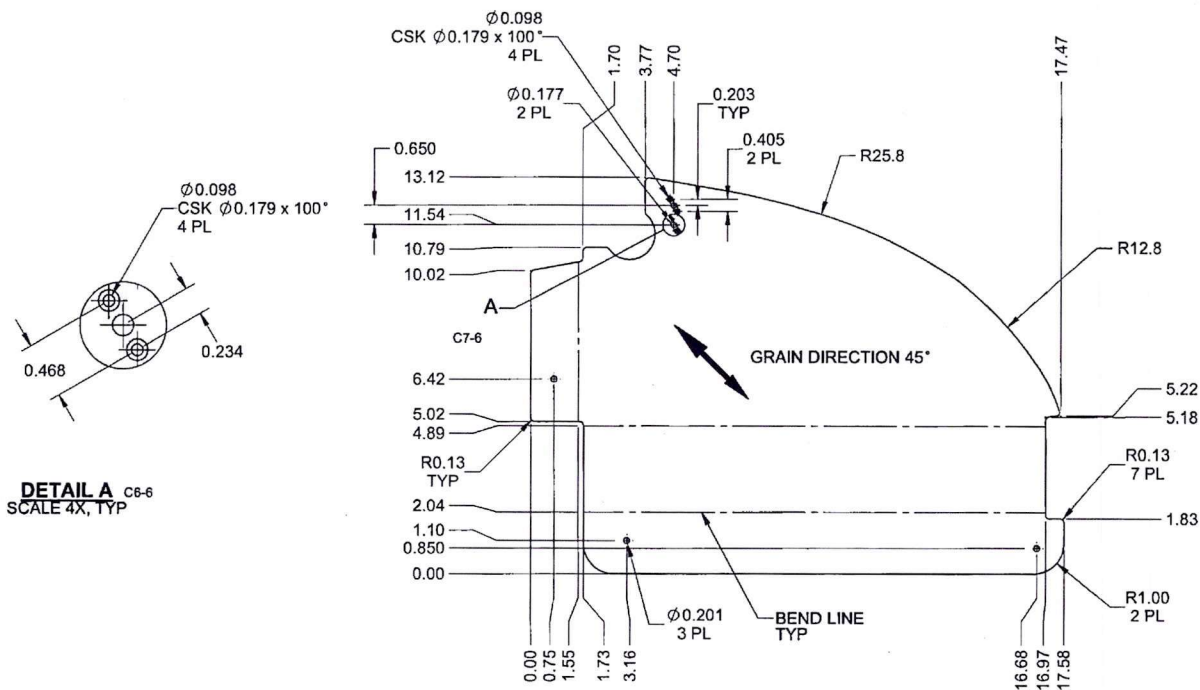
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

RELEASED
2018 OCT 19

APPROVED

DESIGN	PM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4436	SHEET 5 OF 11
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D4436-1F FLAT PATTERN

NOTES:

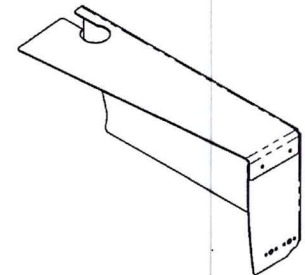
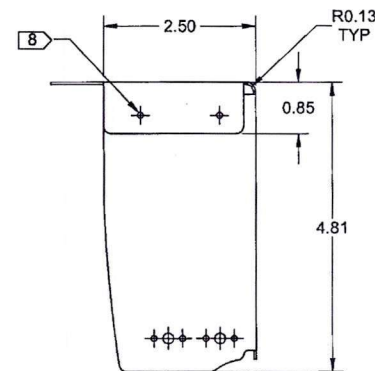
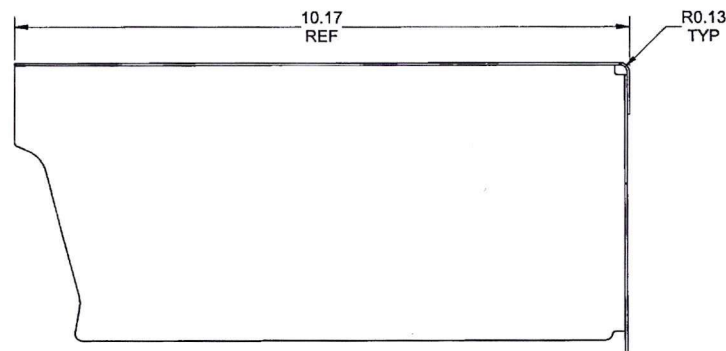
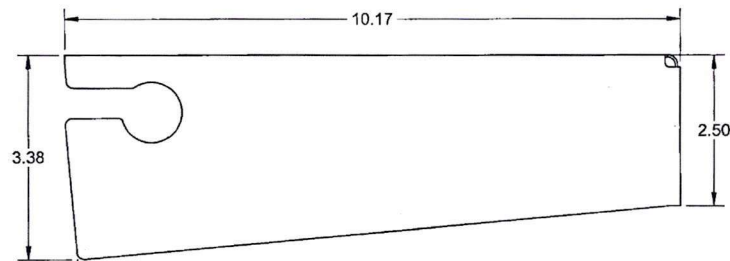
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

RELEASED

2010 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4436	SHEET 7 OF 11
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D4436-3 BRACKET

NOTES:

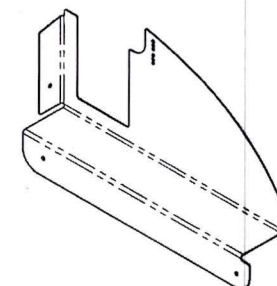
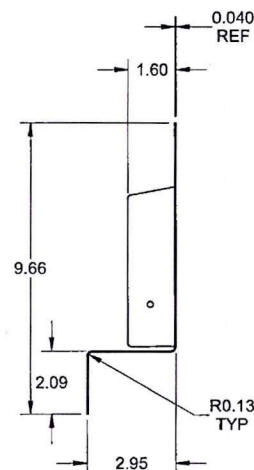
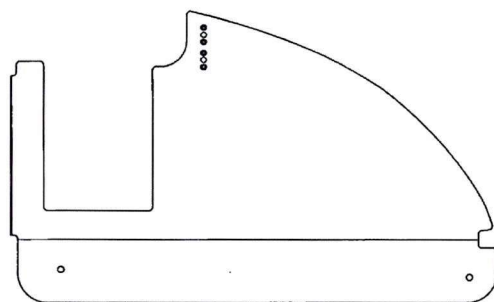
- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

RELEASED

2015 OCT 13

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4436	SHEET 8 OF 11
APPROVED	VS	TITLE	SCALE
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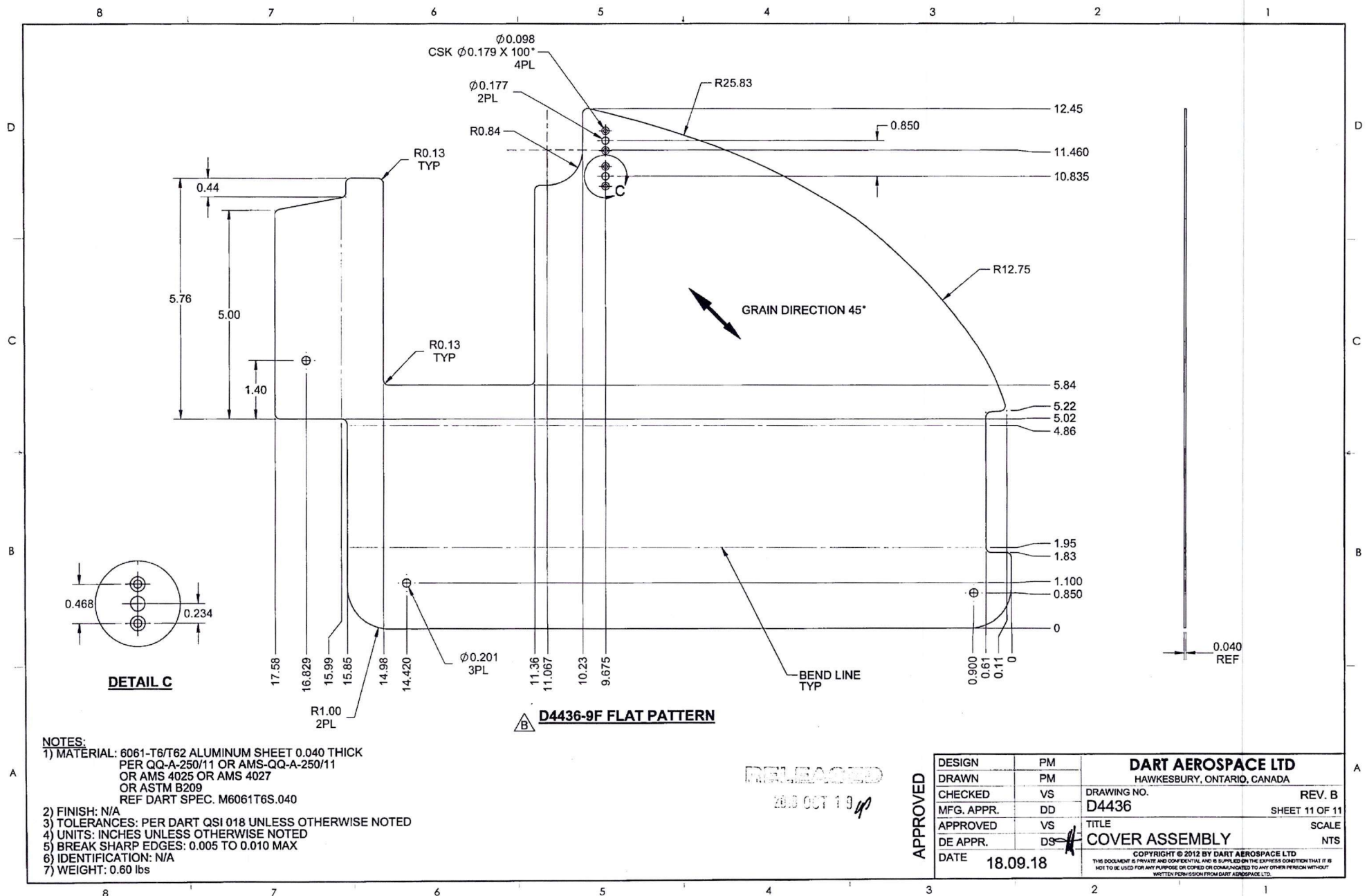
D4436-9 BRACKET

- NOTES:**
- 1) MATERIAL: MAKE FROM D4436-9F FLAT PATTERN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.60 lbs

RELEASED
2013 OCT 19

APPROVED

DESIGN	PM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4436	SHEET 10 OF 11
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Inc.
1270 Aberdena Street
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Container No: S156250



Part: D4436-047

Job No: 188881

Serial No/Batch: S156250

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/25/19